

Date: Thursday, 19/03/2009 4:30:46 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 155 BRACKET  
 Job Number : 46613  
 Estimate Number : 11040  
 P.O. Number :  
 This Issue : 19/03/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D28042  
 Drawing Number : D2804 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 First Issue : / / Type : SMALL /MED FAB  
 Material :  
 Previous Run : 46315 Due Date : 31/03/2009 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : 19030319  
 Comment : Est. A00.11.06 New Issue EC  
 Est. B06.05.30 Blanks on wtjetEC  
 Est Rev:C As per Rev C 06-11-09 JLM  
 Est Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .500 x 12.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 111382

18 9-4-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: E

Prog Rev: E

18 9-4-14

(12)

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



(12) (PTO)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

Y. A

09/04/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(11)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Y. A

09/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-2 PAR #: NA Fault Category: Prod / Mechanical NCR: (Yes) No DQA: D Date: 09/08/05  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 09/05/06

NCR: <u>46613</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/30</u>	<u>3.0</u>	<u>Profile walls are .100"</u> <u>instead of .125" +/- .010</u> <u>offset had been put in</u> <u>wrong column</u> <u>Reoperator error</u>	<u>[Signature]</u> <u>10/11/02</u>	<u>Scrap and <u>destroy</u></u> <u>Qty 1</u> <u>No replace.</u>	<u>N.A</u> <u>09/04/30</u>	<u>[Signature]</u> <u>09/05/01</u>	<u>[Signature]</u> <u>10/11/02</u>	<u>[Signature]</u> <u>05/05/01</u>

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 46613

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mf 09/05/01*

(11)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*UNDP/BK*

*09/05/04*

(K11)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-05-05*

(K14)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*SD149*

*09/05/05*

(11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/05/05*

Job Completion



*mf 09-05-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40013
<b>Description:</b> STA 155 Bracket		<b>Part Number:</b> D2804-2
<b>Inspection Dwg:</b> D2804	<b>Rev:</b> C	<b>Page 1 of 1</b>

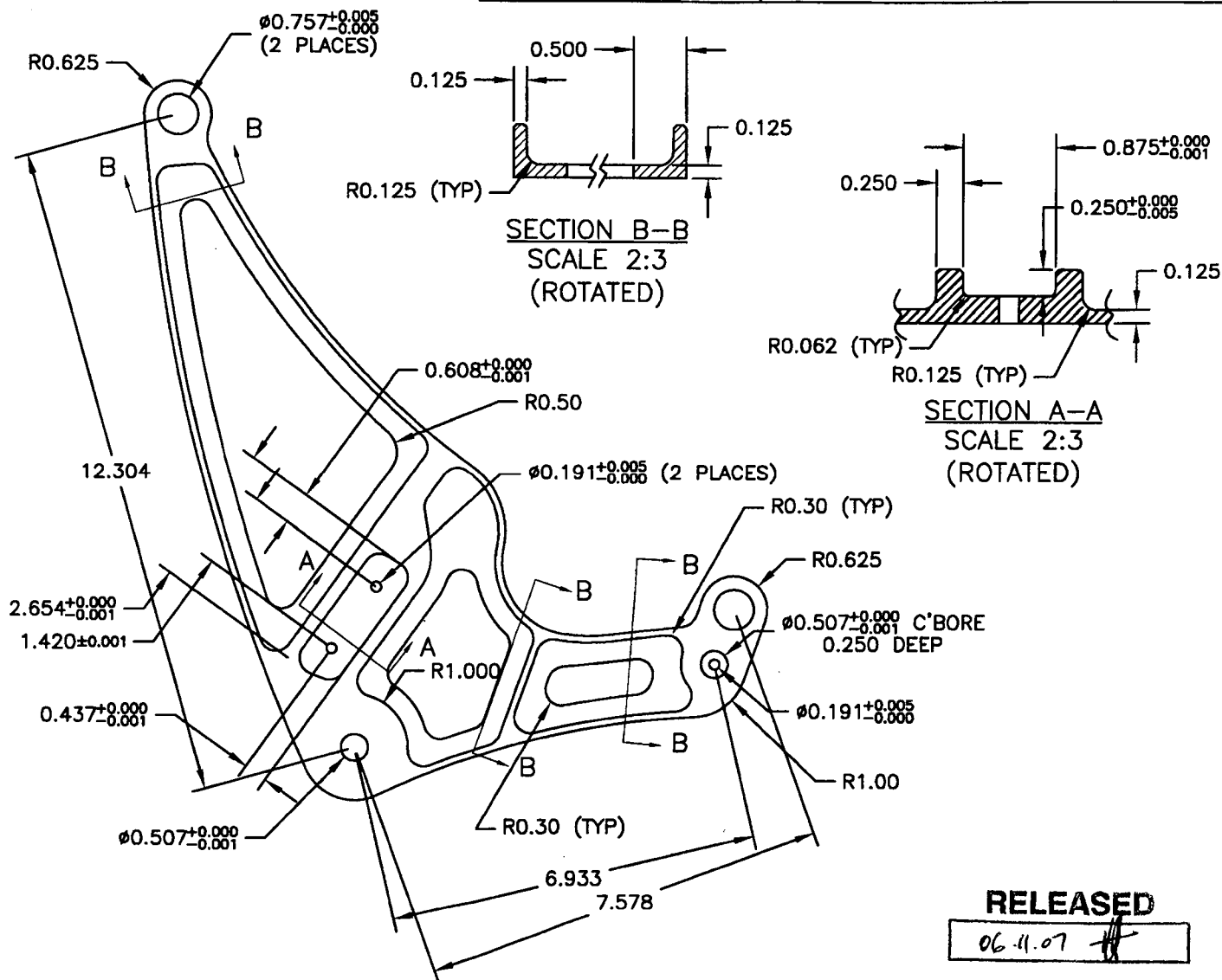
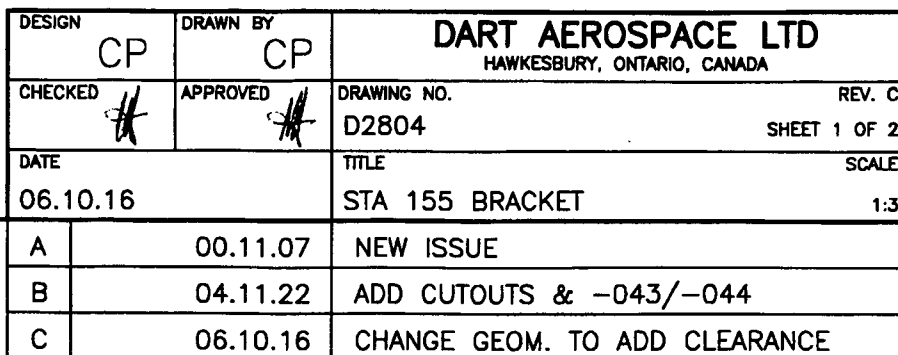
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.128	✓			
0.125	+/-0.010	0.124	✓			
R0.125	+/-0.010	R0.125	✓			
0.250	+/-0.010	0.2505	✓			
0.250	+0.000/-0.005	0.2415	✓			
0.875	+0.000/-0.001	0.8741	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.757	+0.005/-0.000	Ø0.759	✓			
R0.625	+/-0.010	R0.625	✓			
12.304	+/-0.005	12.304	✓			
Ø0.507	+0.000/-0.001	Ø0.506	✓			
0.437	+0.000/-0.001	0.437	✓			
0.608	+0.000/-0.001	0.608	✓			
Ø0.191	+0.005/-0.000	Ø0.194	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	0.252	✓			
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.578	✓			
0.500	+/-0.010	0.492	✓			

<b>Measured by:</b> H.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/04/30	<b>Date:</b> 09/05/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]



1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"  
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

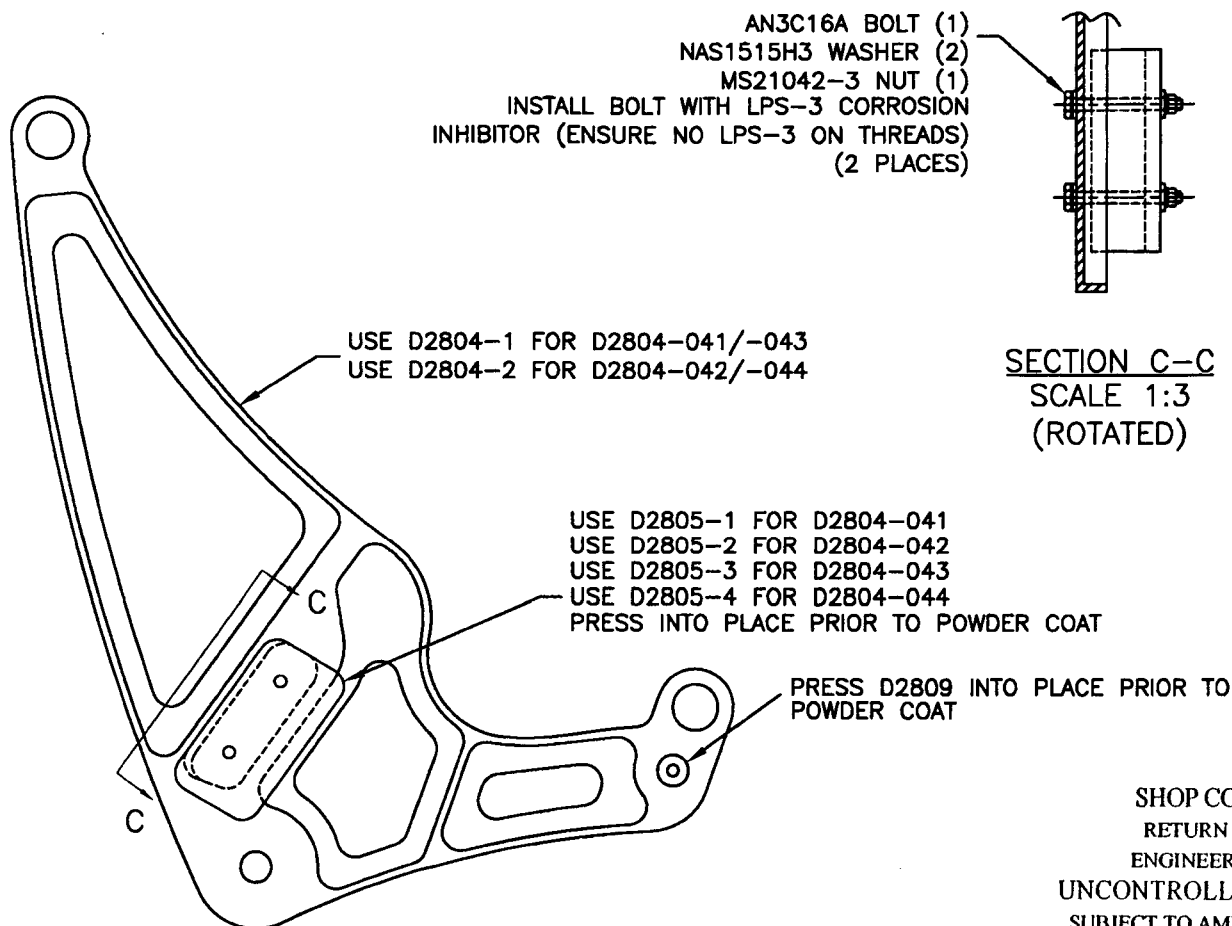
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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**RELEASED**

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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